

Work Order ID 54825

December 22, 2009 1:29:10 PM



Page 1

Item ID: D3705-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 09/12/23 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3705

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705 11 Dwg Rev: C 11 Prog

Rev: C

12- Deburr if necessary

B 10-1-7

6061 . 040



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-1-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ S 1060607



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Page 2

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Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur if necessary.

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10-01-7

9

10-01-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54825

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Item ID: D3705-5

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Revision ID:

Stop



Item Name: Access Panel

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

START TIME:

1:30pm

OVEN TEMPERATURE:

2:00pm FINISH TIME:

320°F

⇒ 11 10-01-13

(X9)

Ø

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BK 10-01-13

Ø

Ø

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Per 10/1/14 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54825

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Page 4

Item ID: D3705-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15
MF
10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:29:10 PM

Page 1

Work Order ID: 54825



Parent Item: D3705-5



Parent Item Name: Access Panel

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No				sf	210.4102	1.2800	3.0		



6061-T6 .040 Sheet

B 10-1-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

210.4102

100742

3.3

102723

5.93

105842

12

106747

5.7516

107461

11.7841

109396

17.9316

111224

23.0629

113004

129.15

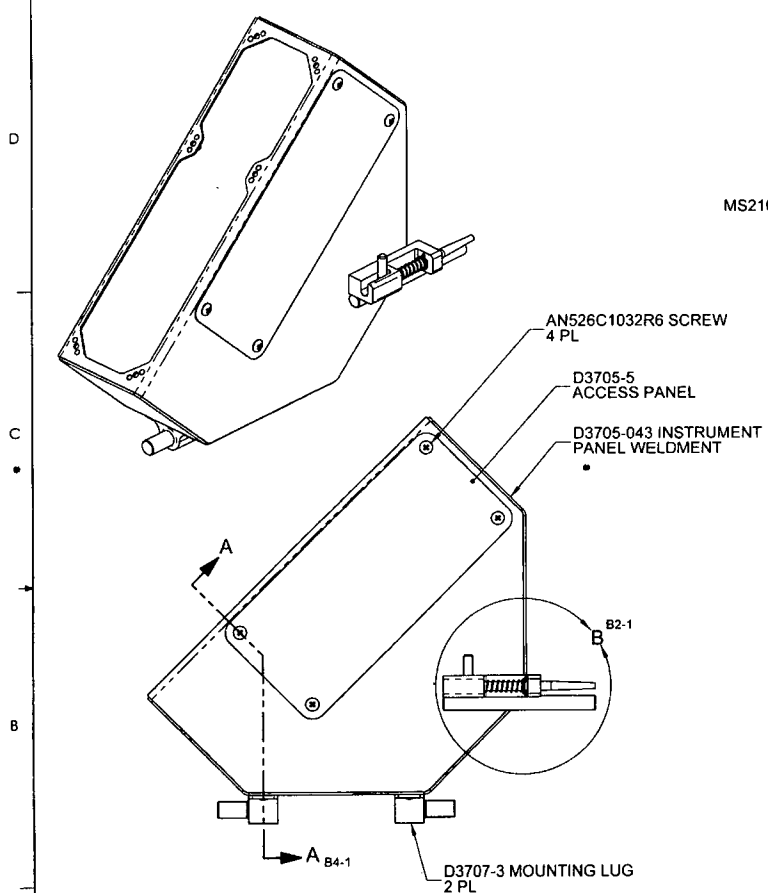
19380

1.5

107461

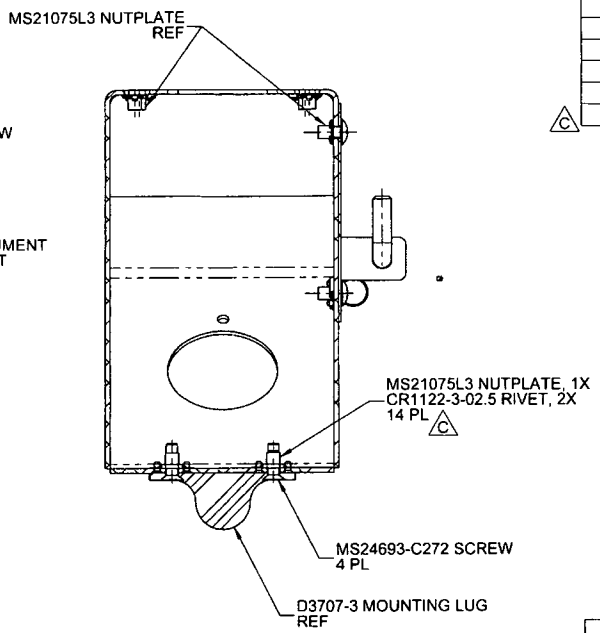
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8 7 6 5 4 3 2 1



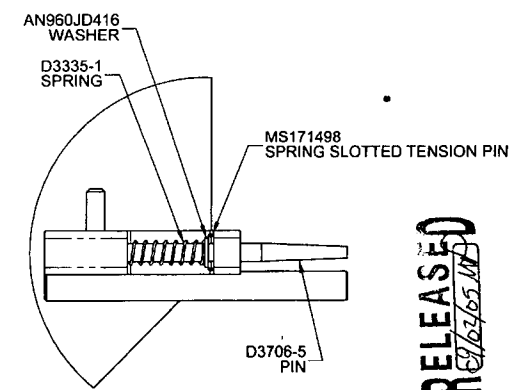
D3705-041 INSTRUMENT PANEL ASS'Y

- D3705-041 NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.97 lbs



SECTION A-A
SCALE 2X
B7-1
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WORK ORDER
NO. 54825
C209112/23

ITEM	QTY	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



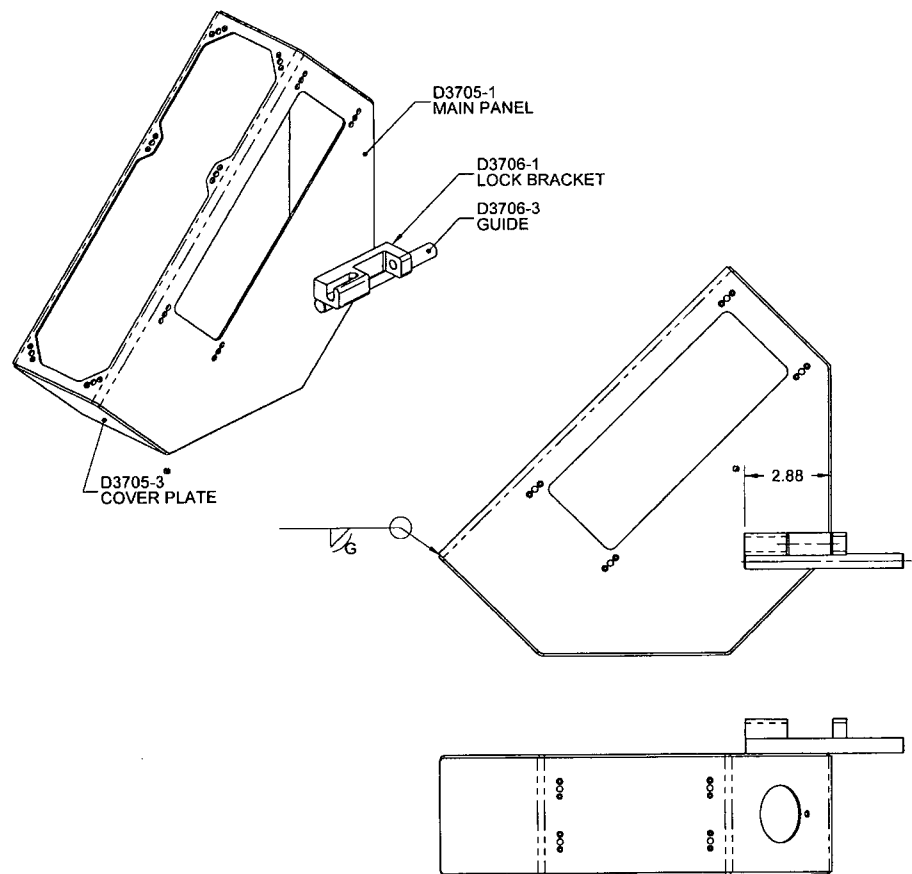
DETAIL B
SCALE 2X
B6-1

C	ADDED D3705-7/9/11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.38 AND 12.61 (ZN B6-3); Ø 1.90 WAS 1.50 (ZN D5-4); ADDED Ø 0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27038-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3); REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	LB		
DRAWN	B		
CHECKED	FJS		
MFG. APPR.	DS		
APPROVED	MP		
DE APPR.	MP		
DATE	08.11.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3705			
TITLE INSTRUMENT PANEL ASS'Y			
SHEET 1 OF 6			
REV. C			
SCALE NTS			
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RELEASED
R6162/65 MB

8 7 6 5 4 3 2 1

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

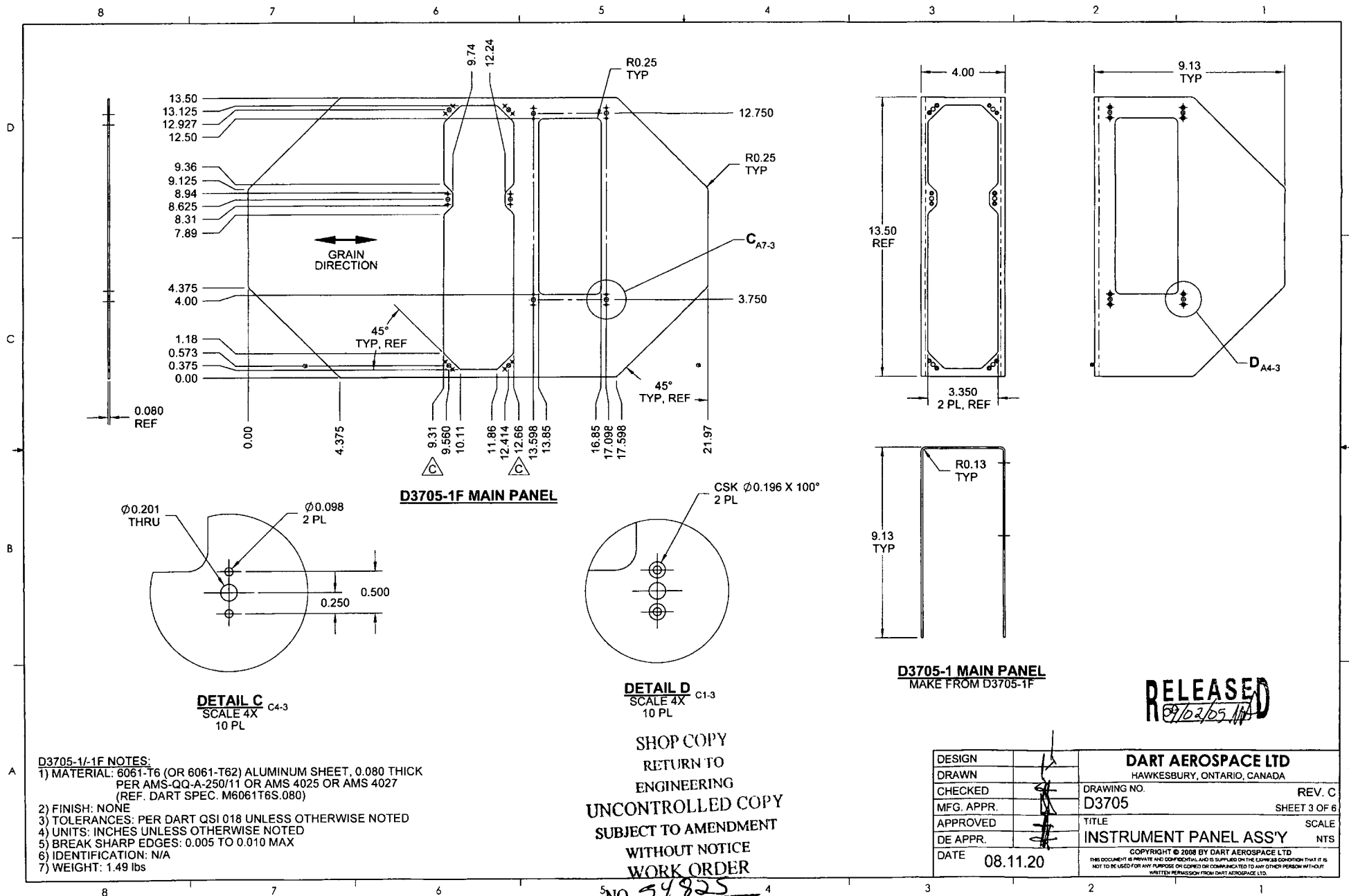
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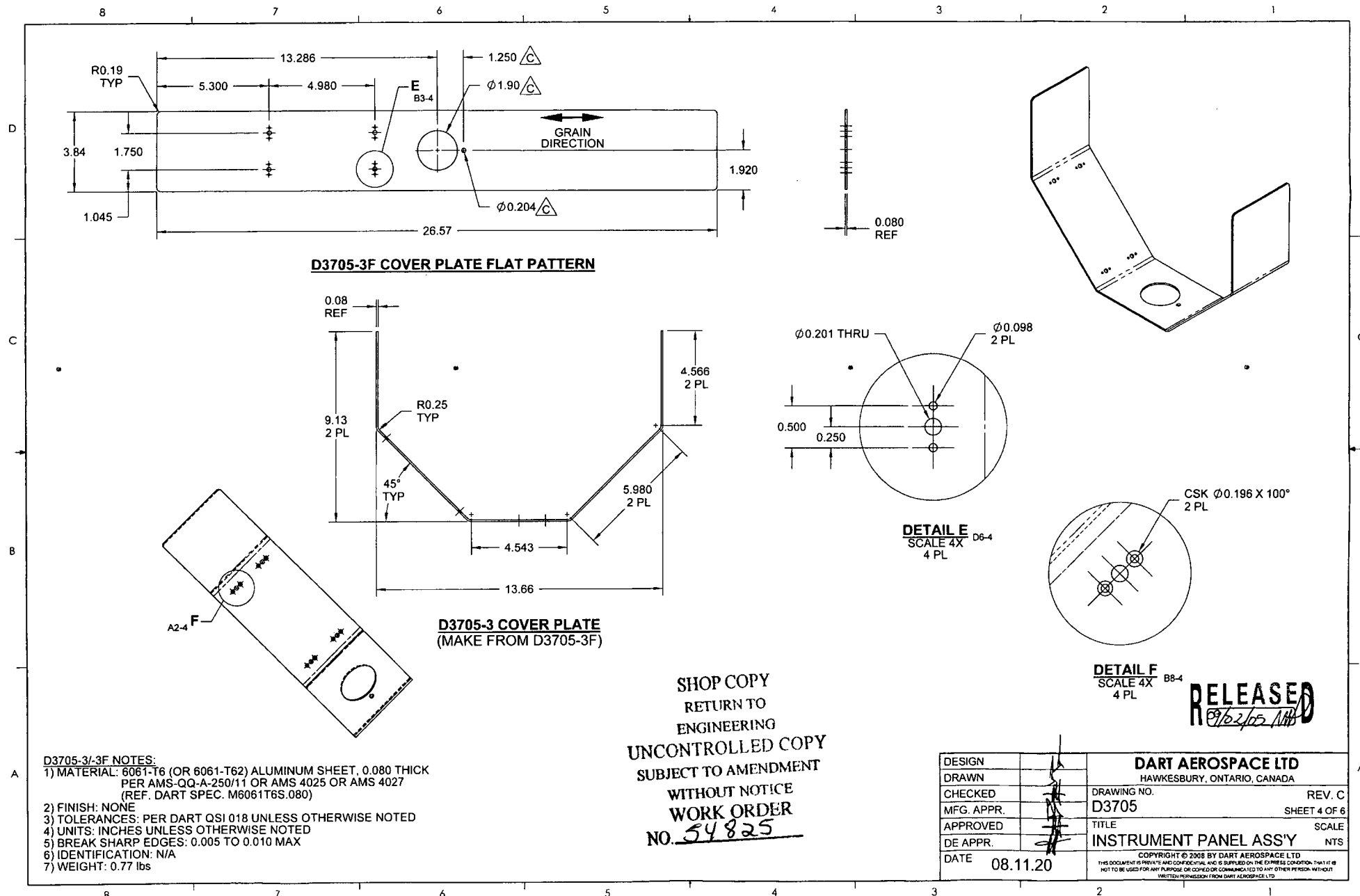
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

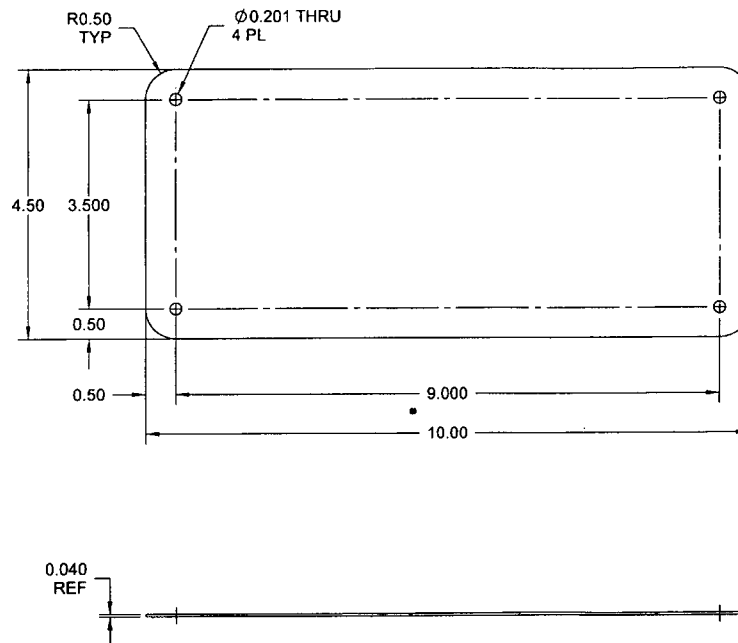
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NO. 54825

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8/12/05 N/A

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D3705-5 ACCESS PANEL

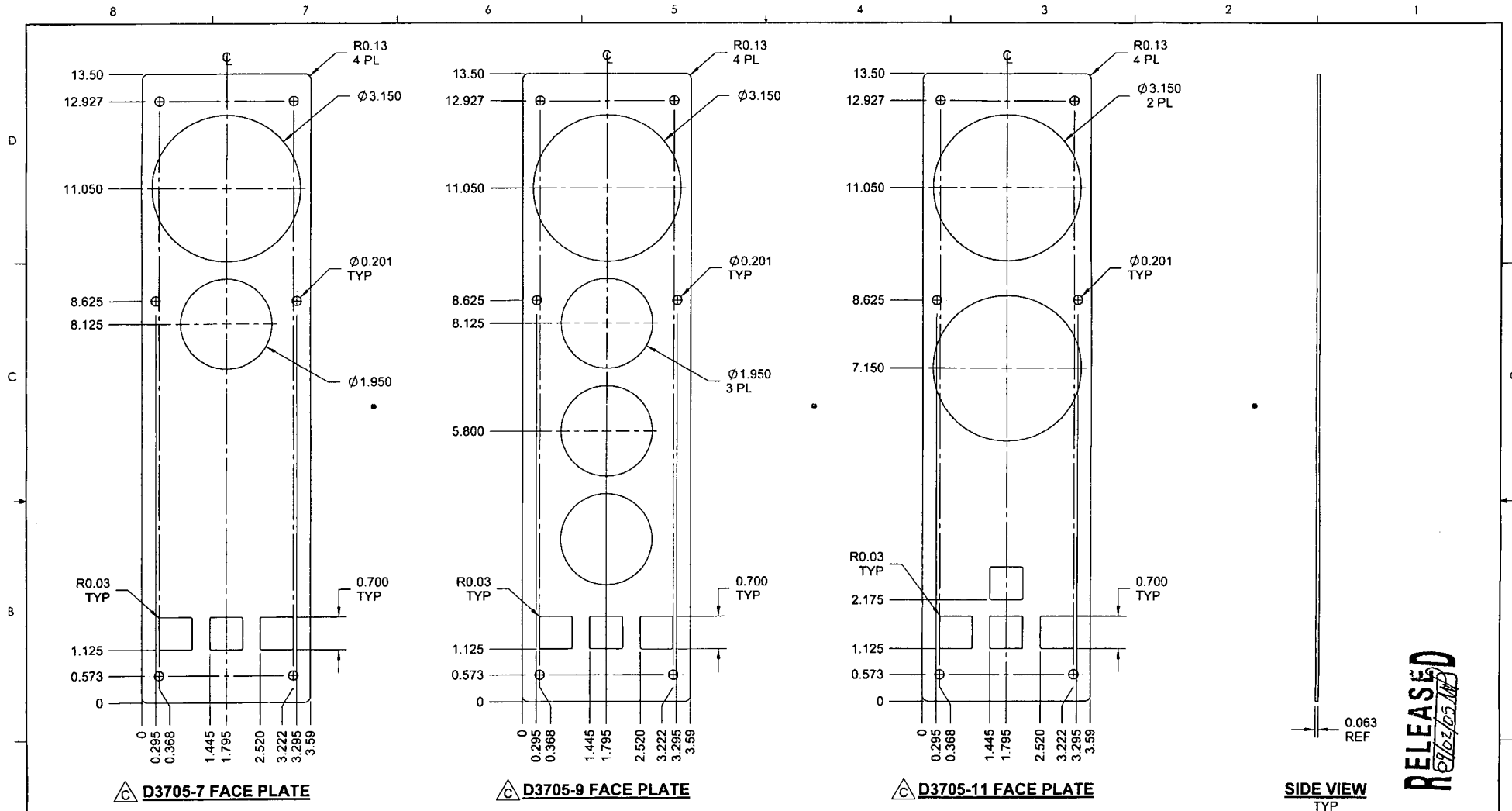
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RELEASED
9/12/05

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

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MFG. APPR.		D3705	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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D3705-7/-9/-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

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R 08/02/05 MJP